NCR: (Ye) / No See pure 13-3279

DQA TWO Date:	14/01/02
	1 /

	1119 111				A STATE OF				- 10%		QA Closed:	Date.	191200
Work Orde	er:	10	594	0		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	V
				No.		Rework		Skid-tube Crosstube			1	Water Jet	Engineering
Part N	lo.	D	200	50-	9	Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Region of	Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	CR No. 13-3280		Work Order Update			Large Fab	Composite		Supplier				
E. I	<b>建设设置</b>									*			
Root	10				Descr	iption of work order update	In	itial	Act	tion	Sign &		2/ 24 W
Cause		Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data		alala	160	21.0	Lan	has to be	S	1	ad bo	d to	DAS	29	DAS
Equip/Tooling	LIIV	13/12/02	180	248	trui	100			Sort Da	ch to	27	Jul 9-89	ATT 29 9-89
Operator			( 60 P		re-	sounder and her			Customa	tion	13/11/02	10/07	13/12/02
Material				1	L	1-2000s COU! 124						13/12/02	1311402
Setup	4 4		1.55		1 re	pander and by supplier			le-pour	de wat			100
Other	1		4,350	- 5	0	17/2			0-0	^			
Process					K.C	not enough			us plan	Burg			
Supplier .	×,				Douder cool of					~			
Training			OF IN	Min.									
Unapproved		ui C			l D	ame area							4-33
	-4						AULT	CATE	GORY				
Landi						General					1	_	7
ķ		Bending	200	E		Bend	-	Grain		-	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	0/5	BOM/Route	$\mathbf{H}$	lardwa			Over/Under		Temperature/Cure
7-1	-	Cracks				Broken/Damaged			on Incomplete		Part Incorred	_	Weld
- 1914	-	Crushed/	Crimped			Burrs			ions Incomplete/L	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
10 No. 20	Cuffs Contamination		$\mathbf{H}$		nance	_	Part Moved						
i. i	Heat Treat Countersink Inspection Strip in Tube Cut Too Short			$\vdash$	Mislabe		nia -	Positioned V		Tour .			
A		The Residence		Tune		Cut Too Short	$\vdash$	Misread	- March 18		Power Loss/	Surge	Other
		Ripples in		T. A.	5.5	Drill Holes	$\mathbf{H}$	Offset	Calibaration				
		Torque W			1 5 50	Drawing	$\vdash$		Calibration		-		
		Turning S	The same of			Finish	$\vdash$		Sequence				
		Wave/Tw	rist in Tu	be	INCHES OF	Folio		Jutside	Dimensions	ALCOHOL:	- Callery	THE PERSON	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, August 27, 2013 7:30:15 AM

\*105940\*

Page 2

	D2230-3		Accept	*N900	040100	* Setup Sta	rt *NS1*
Revision ID: Item Name:	MOUNTING LUG					Sto	*NS2*
Start Date: Required Date: Reference:	8/27/2013 Start Qty: 250.00 9/20/2013 Req'd Qty: 250.00	*250 *250		Cust Item II Customer:	);		1
Approvals:	Process Plan:	Date:	Tooling:	Da	te:	Run Sta	INKI
	QC:	Date:	SPC (Y/N):	Da	te:	310	" *NR2*
Sequence ID/ Work Center II  140  *140* HandFinish Hand Finishing  150  *150* QC Quality Control	Operation Description Chemical Conversion Con Memo  QC3- Inspect Part Finish Memo	at per QS1005 4.1	Set Up/ Run Hours 0.00 A.T 0.00 P.00 0.00	Tool ID  C- ; 21082	Tool # Plan Code	Accept Reject Qty Qty	Reject Insp. Number Stamp
*160 *160* Powdercoat Powder Coating	White Gloss(Ref.4.3.5.1)  Memo START TIM OVEN TEM FINISH TIM	E: PERATURE: E:	0.00 0.00 A.TG- R	10:21082	s *	CZ 1=	3/11/28

				<b>POSE</b>	
N	CD-	THE	Yes	1	No
N					INU

DQA:	Date:	
A SECOND AND SECOND		

NCK.	es / 140	L.Fru.			WORK ORDER HORE	CONTR		MANCE / OF D		QA Closed:	Date	. 34
Work Orde	rc-III	731			DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
				alle V	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.			No.	Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	Use-as-is				Th		noforming	Finishing		re/Packaging	Other	
NCR No. Work Order Update				1   "		Large Fab	Composite		Supplier			
	Treats I	phone.		4.7		1						
Root		HI TO SEE	185-	Desc	ription of work order update	Initia	al	Actio	on	Sign &		5 × 12 × 14 × 14 × 14 × 14 × 14 × 14 × 14
Cause	Date	Step	Oty		or Non-conformance	Chief I	Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data	N. GURLA				9755-1100							
Equip/Tooling	THE STATE		J. P.								· ·	
Operator						İ						
Material					100						ŀ	
Setup		1 5 5			Alice and the second se							
Other		1	labin.								i i	
Process			HH									
Supplier								+	Ï			
Training							8				100 g 2	· · · · · · · · · · · · · · · · · · ·
Unapproved				1 Sets	W1					**		
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Landir	ng Gear				General		æ.			la a		<b>-</b>
	Bending		2 # 0		Bend	Gra				Ovalized	-	Pressure/Forced
		Not Conce	ntric ta	0/5	BOM/Route	1000000	rdwa		-	Over/Under	Charles and Allert March and Control	Temperature/Cure
10 H	Cracks				Broken/Damaged	-		ion Incomplete		Part Incorre	-	Weld
	Crushed/Crimped Burrs				ions Incomplete/U	<u> </u>	Part Lost/Mi	issing	Wrong Stock Pulled			
		Cuffs Contamination				enance		Part Moved				
0/4 B	Heat Treat Countersink			slabe			Positioned V		Tout as			
		on Strip in	Tube		Cut Too Short	-	sread	1		Power Loss/	Surge	Other
	Ripples			1130	Drill Holes	Off						
9	19/200	Waves in I		n	Drawing			Calibration				Ten.
	The second second	Sequence			Finish			Sequence				
10	Wave/T	Wave/Twist in Tube Folio				Out	Outside Dimensions					

<sup>.</sup> H:/FORMS/Quality Assurance\approved QA/NCRWIO Rev G

Page 3

Insp.

. Work Order ID 105940 \*105940\* Tuesday, August 27, 2013 7:30:15 AM Accept \*N900040100\* Setup Start D2230-3 Item ID: Revision ID: MOUNTING LUG Item Name: \*250\* Start Qty: 250.00 Cust Item ID: 8/27/2013 Start Date: Required Date: 9/20/2013 Reg'd Qty: 250.00 \*250\* Customer: Reference: Run Start Date: Date: Tooling: Process Plan: Approvals: Stop Date: Date: SPC (Y/N): QC: Tool ID Tool # Plan Accept Reject Reject Set Up/ Sequence ID/ Operation Code Qty Qty Number Stamp Description Run Hours Work Center ID Qua Inspect Part Finish 0.00 170 \*170\* QC Memo Quality Control Identify as per dwg & Stock Location 180 \*180\* 0.00 Packaging Memo

0.00

0.00

Packaging

190

\*190\* QC

Quality Control

OC21- Final Inspection - Work Order Release

Memo

DAS 26

Rm 13/12/18

MV 12-18

(3-12-18

N	CR	3 10	Yes	1	No
100	CI		100		INC

DQA:	Date:	
//		2 000

		F								QA Closed:	Date:	
Work Order					DISPOSITION	1		Skid-tube	AGAINST D	EPARTMENT	/PROCESS Water Jet	Engineering
Part No. Scrap Use-as-is NCR No. Work Order Update					Therm	Machining noforming Large Fab	Small Fab Finishing Composite	_	d. Eng. Coor. re/Packaging Supplier	Quality Other		
Root Cause	Date	Step	Qty	Descr	iption of work order update	100.7.00	nitial Action			Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Step	3				nief Eng Description				Vermeditori	
						AULT	CATE	GORY				
Landin	g Gear  Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque V Turning S	Crimped at in Strip in in Bend Vaves in E	Tube		General  Bend  BOM/Route  Broken/Damaged  Burrs  Contamination  Countersink  Cut Too Short  Drill Holes  Drawing  Finish	H In In N N N O O	nstruct Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/U nance Iled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Twist in Tube Folio		0	Outside Dimensions								

<sup>,</sup> H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Required Date: 9/20/2013

Required Qty: 250.00

Start Date: 8/27/2013

Start Qty: 250.00

\* Tuesday, August 27, 2013 7:30:15 AM

Work Order ID:

105940

Parent Item:

Comments:

D2230-3

Parent Item Name:

MOUNTING LUG

IPP D00.05.18Added inspection level 8, and removed P/O for powder

coatEC BY:EC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

87953

93551

Metec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status 13/4/28
D2230-3P LUG		Purchased	No				Each	0.0000		250	1009	40 /	by 8mu
D2423 Lug Extrusion		Manufactured	No				f	268.9220		17.97368	34 CXI	3/10	125
				Location MAT006		Loc Qty 221.5	Lo	oc Code		-2-			

221.5 47.422

47.422

N	CR:	Yes	/ No
A.	C11.		1000

DQA:	Date:	# -

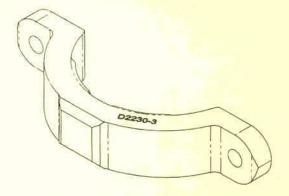
					WORK ORDER HORE			WINITELY OF	DATE	QA Closed:	Date:	
Work Order					DISPOSITION			4.	AGAINST DE	PARTMENT	/PROCESS	1. 1
Part No	Rework Scrap			Skid-tube Crosstube Machining Small Fab			Prod. Eng. Coor.  Rec/Store/Packaging		Engineering Quality Other			
NCR No	i.				Use-as-is Work Order Update		mem	noforming Large Fab	Composite	, Rec/stol	Supplier	Other
Root				Desc	cription of work order update	1	nitial	Ac	tion	Sign &	100	
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data					T Mari			1.50				
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Operator		188		F 0				. 1				
Material		-										ak a F
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Other				2 94A								
Process			3									
Supplier				The second				000				35
Training				100	¥							
Unapproved			- 1	SICHLE	N I	ALII	T CATE	GORY				1 3
Landing	Geor .	-		200	General	HOL	CAIL	GONT			<del>,</del>	y C- 3-au
	Bending			r	Bend		Grain			Ovalized		Pressure/Forced
E	Centre No	ot Conce	ntrie to	0/5	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
東 東	Cracks				Broken/Damaged		and the second	ion Incomplete		Part Incorre	51,660,000,000	Weld
	Crushed/	Crimped		S 2 2 5	Burrs		Transfer out	ions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		-	enance		Part Moved	S1 -	
	Heat Trea	at		# 2	Countersink		Mislabe	eled		Positioned V	Vrong	-
A. Tank	Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other
	Ripples in	Bend		2005 B	Drill Holes		Offset		1			VF-
1	Torque V	Vaves in E	Extrusio	n	Drawing		Out of	Calibration				ti all
	Turning S	equence			Finish		Out of	Sequence				
	NA PROPERTY	OF STREET OF STREET	TO SA	Charles I.S.	F-U-		Outsid.	Dimensions				

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D2230-1



CX13/08/27 W10: 105940



D2230-3 MOUNTING LUG



STAND	ARDS REFER TO PREVENT (	O SECTION A-A & B-B FILLET	AJS	09.01.16			
REDES	IGN; R1.200 WA	\$ 1.100	CP	99.12.13			
RE-DES	SIGN		BW	95.01.04			
RE-DES	SIGN	BW	95.01.04				
RE-DES	SIGN	BW	94 03.30				
	1	DESCRIPTION	BY	DATE			
N	BW	DART AEROSPA	CEL	TD			
N	AJS	HAWKESBURY, ONTARI	HAWKESBURY, ONTARIO, CANADA				
ŒD	71	DRAWING NO.		REV. G			
PPR.	Und.	D2230 SHEET 1					
OVED	(MP)	TITLE		SCALE			
PR	1-4	MOUNTING LUG		NTS			
	STAND ADDED INSTAL REDES RE-DES RE-DES RE-DES N N N CED APPR.	STANDARDS, REFER ADDED TO PREVENT (INSTALLATION) REDESIGN, R1.200 WARE-DESIGN RE-DESIGN RE-DESIGN N BW N A.S GED APPR. DVED	REDESIGN, R1.200 WAS 1.100  RE-DESIGN  RE-DESIGN  DESCRIPTION  DART AEROSPA  HAWKESBURY, ONTARI  DESCRIPTION  DART AEROSPA  HAWKESBURY, ONTARI  DESCRIPTION  DART AEROSPA  HAWKESBURY, ONTARI  DESCRIPTION  DESCRIPTION  THE	STANDARDS. REFER TO SECTION A-A & B-8 FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.  REDESIGN; R1.200 WAS 1.100 CP  RE-DESIGN BW  RE-DESIGN BW  DESCRIPTION BY  N BW  DART AEROSPACE L  HAWKESBURY, ONTARIO, CANA  DRAWING NO.  D22.30  D22.30  D23.11 LE			

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANDES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS
OF 0.015+0.005.

OF 0.015±0.005. 7) WEIGHT: -1: 0.16 lbs -3: 0.14 lbs

DATE

09.01.16

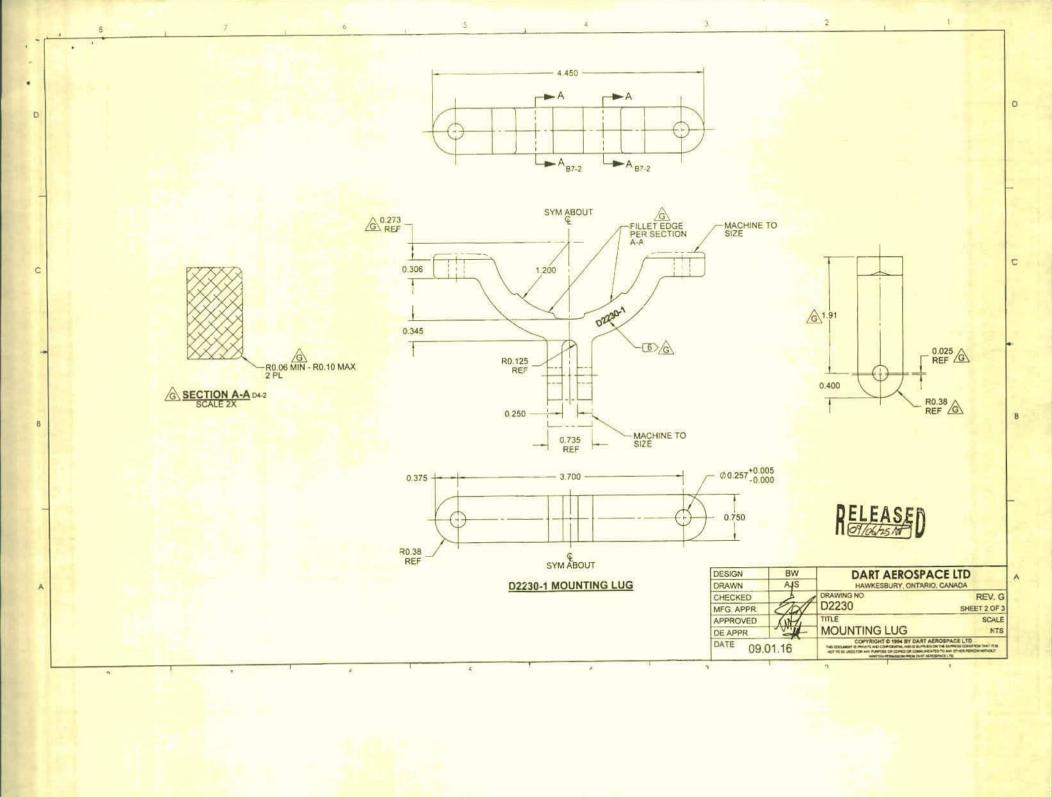


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IN	CR:	Yes /	No
•			F-70-700

DQA:	Date:	
		2-1

		7	16			WOMIN ON DER NOW					QA Closed:	Date:	
Work Orde	er:		1			DISPOSITION		AGAINST DEPARTMENT/PROCESS				-, -	
		de de		154		Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part No. Scrap			1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality					
	E.		11-41	-		Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	lo.		711	110	100	Work Order Update			Large Fab	Composite		Supplier	
L					-ol								A Parameter Annual Para
Root				HAI	Desc	ription of work order update	1 5	nitial	10000	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Equip/Tooling									, 11- e-				上""
Operator			e le lo										
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Setup						* 1 to 1							
Other			CIPI										F : 488
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Supplier									The state of				
Training			-		150								
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Landin						General		7			1		7
		Bending				Bend		Grain		-	Ovalized	-	Pressure/Forced
F 200 0 F	_	Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa			Over/Under	-	Temperature/Cure
		Cracks				Broken/Damaged			ion Incomplete	_	Part Incorre		Weld
		Crushed/	Crimped			Burrs		-	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	-	Cuffs				Contamination		Mainte		_	Part Moved		
1 kz . 1	-	Heat Trea			The Na	Countersink		Mislabe			Positioned V		7
E		Inspectio	100	Tube	B. (18)	Cut Too Short		Misrea	d	L	Power Loss/	Surge	Other
		Ripples in			70 1000	Drill Holes		Offset					1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
1	18	Torque W			n	Drawing		400000000000000000000000000000000000000	Calibration				
		Turning S			11.	Finish		- POW	Sequence				
		Wave/Tw	vist in Tub	oe	ALL MALES	Folio		Outside	Dimensions	4-14-5	303/ 1-1-	To the state of	

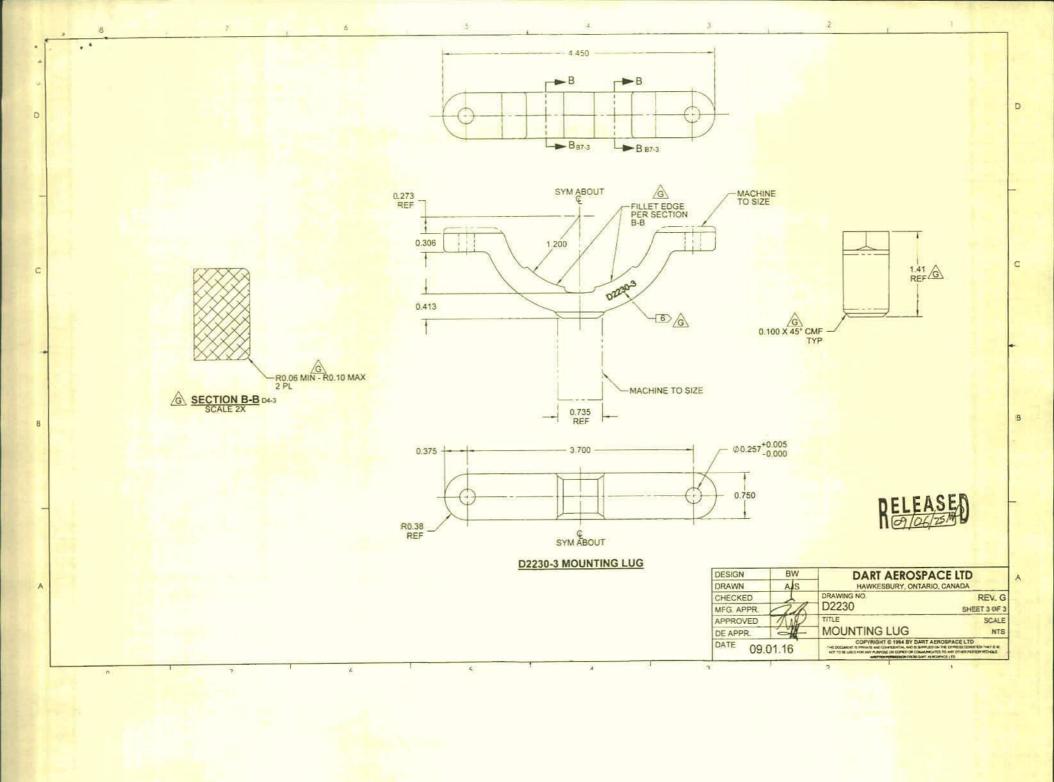
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N	Cn.		62		NO

DQA:	Date:	
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		313			22			,		QA Closed:	Date	
Work Order		1	P.		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. S				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root				Desc	cription of work order update	l	nitial	Act	tion	Sign &		N OF STREET
Cause	Date	Step	Qty	- Very	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
		729	1		F	AUL	T CATE	GORY				1 112
Landin	Bending Centre N	ot Conce	ntric to	o/s	General Bend BOM/Route		Grain Hardwa			Ovalized Over/Under		Pressure/Forced Temperature/Cure
	Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink				Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled		Unclear	Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	issing Vrong	Weld Wrong Stock Pulled Other		
	Inspectio		Tube		Cut Too Short Drill Holes	-	Misrea Offset	u		J-ower coss/	Julge	other as
	Ripples in Torque V	Vaves in		n	Drawing		Out of	Calibration				
	Turning S Wave/Tv				Finish Folio	-		Sequence e Dimensions				
	vvave/1v	AIPT III I II	ne .		1000		Outside	Difficusions				_22.0



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DQA:	Date:	
		NEE .

		•	QA Closed: Da	ite:
Work Order:	DISPOSITION		EPARTMENT/PROCESS	
	Rework	Skid-tube Crosstube	Water Jet	
Part No.	Scrap	Machining Small Fab	Prod. Eng. Coor.	
	Use-as-is Use-as-is	Thermoforming Finishing	Rec/Store/Packaging Supplier	
NCR No.	Work Order Update	Large Fab Composite	Jupplier	
Root Descri	ption of work order update	Initial Action	Sign &	
Cause Date Step Qty C	or Non-conformance	Chief Eng Description	Date Verification	on QC Inspector
Doc/Data	Y -			
Equip/Tooling	1			
Operator	1			
Material				70
Setup	1			
Other				
Process				
Supplier				
Training	2			
Unapproved				100
		JLT CATEGORY		1,80
Landing Gear	General	Te ·	Ovalized	Pressure/Forced
Bending	Bend	Grain	Over/Under tolerance	Temperature/Cure
Centre Not Concentric to O/S	BOM/Route	Hardware	Part Incorrect	Weld
Cracks	Broken/Damaged	Inspection Incomplete Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
Crushed/Crimped	Burrs Contamination	Maintenance	Part Moved	
Cuffs	Countersink	Mislabeled	Positioned Wrong	
Heat Treat	Cut Too Short	Misread	Power Loss/Surge	Other
Inspection Strip in Tube Ripples in Bend	Drill Holes	Offset		1998
Torque Waves in Extrusion	Drawing	Out of Calibration		
Turning Sequence	Finish	Out of Sequence		
Wave/Twist in Tube	Folio	Outside Dimensions	the state of the s	-51



A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE STREET ROCKLAND, ON K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

#### Pack List

Number: 906958

Date: 28-Nov-13

To

DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 Canada

Ship To

CHANTAL LAVOIE DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ph: 613 632-9577 Fax: 613 632-1053

Terms		Ship Via		
Quantity	Description			
	PLEASE REFERENCE THE PACK SHIPMENT. IF YOU HAVE ANY QUESTIONS,			
248 ea	Part: D2230-3P MOUNTING LUG Job: 14996	PO: PO21082	Rev: G Line: 1	
123 ea	Part: D3235-1P MOUNTING LUG		Rev: A	
ca	Job: 14997	PO: PO21082	Line: 2	
	Part: D3910-3P X-TUBE LUG		Rev: B	
	Job: 14998	PO: PO21082	Line: 3	
	A.T.G. INDUSTRIES INC. CERTIFI CONFORMANCE WITH THE REQ REFERENCED IN THE ABOVE PU	CATE OF CONFORMANCE STHAT ALL ITEMS IN THIS SUIREMENTS, SPECIFICATIONS	S, AND DRAWINGS	

